

line (A-A line) and numerous cuts 31 and 32 are made along the cut end surfaces of this cut line 30 as shown in Fig. 6(a) prior to moving on to the next step. Making these cuts 31 and 32 allow the narrow rectangular pleated component 16 to be formed in the bulging component 40 itself.

Next, the sheet bundle 21 is bent in two along the first bend line (A-A line) so that the pleated component 4 on the one side 24 will overlap with the pleated component 4 on the other side 25 (first bending step).

10 The seal component 6 is then formed near the pleated component 4 as shown in Fig. 4(b). Heat fusion is the preferred means for forming the seal component 6. In the second and third embodiments the second seal component 17 is provided in addition to the seal component 6, a suitable
15 distance away (Figs. 5(b) and 6(b)).

The result of thus forming the seal component 6 is that the bulging component 40 is formed demarcated from the pleated component 4, a space is formed on the inside of this bulging component 40, and this space constitutes the handle
20 insertion component 3. In the second and third embodiments the space (handle insertion component 3) is formed between the two seal components 6 and 17.

Next, in the first, second, and third embodiment, as shown in Figs. 4(b), 5(b), and 6(b), respectively, the sheet

bundle 21 is bent in two so that the pleated components 4 overlap with each other along the second bend line (B-B line) that passes at a right angle through the center of the first bend line (A-A line) (second bending step). Thus
5 bending the sheet bundle 21 in two-steps, i.e. in the first bending step and in the second bending step, yields the cleaning component 2. The first bend line (A-A line) corresponds to the bent component 9, while the second bend line (B-B line) corresponds to the bent component 7.

10 The bulging component 40 is curved in a U-shape as a result of the second bending step described above. Next, the U-shape is fixed by linking through heat fusion of the like near the insertion openings 8a and 8b in the handle insertion component 3 of the bulging component 40. This
15 yields the cleaning component 2 comprising the bulging component 40 curved in a U-shape and the pleated component 4 formed along and underneath the bulging component 40. Support members 10a and 10b of the handle component 5 are inserted into the handle insertion component 3 through the
20 insertion openings 8a and 8b, respectively, in the handle insertion component 3 of the cleaning component 2 formed as above, and the cleaning component 2 is fixed to and supported by the distal end of the handle component 5. The cleaning component 2 is removable attached to the handle
25 component 5.